

Work Order ID 53335-

October 30, 2009 1:11:14 PM



Page 1

Item ID: PB67-43001-31
 Revision ID: B1 C PRELIM 09.12.21
 Item Name: PB67-43001-31 Upper Restraint Weldment
 Start Date: 11/2/2009 Start Qty: 6.00
 Required Date: 11/23/2009 Req'd Qty: 6.00

Accept

Split S/S



Setup Start



Stop

Cust Item ID:
Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: MF

Date: 09-10-30 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B67-43001	REV-B1 REV. C 09.12.21
-----------	------------------------

100



Waterjet

FLOW CNC Waterjet

6001
.040

FLOW WATER JET

0.00

B9-12-17 R
B9-12-9 ⑧

110



QC

Quality Control

Memo

0.00

B9-12-17
B9-12-9

⑦

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

S091216 ⑥④

Memo

0.00

→ S091209

X12 6

QC8- Inspect parts - second check

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 11/2/2009 Start Qty: 6.00



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**Reference:**

Approvals: Process Plan:

Date: Tooling: Date:

Run Start



QC:

Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Brake NC

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp
7 8 9

Ph →

86 09/01/22

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ 81

S. Colodar

7

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

→ 81

10/01/24

X 7

O

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling: Date:

Run Start



QC:

Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Brake NC

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp
7 8 9

Ph →

86 09/01/22

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ 81

S. Colodar

7

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

→ 81

10/01/24

X 7

O

W/O:		WORK ORDER CHANGES					
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Part No: PB67-43001-31 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 53335		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.12.16	130	1 part crack at the bend ROOT CAUSE: MFG DID NOT CONSULT ENG. PRIOR TO RELEASE IN WD.	09.12.16	Scrap + destroy No replace PER REV. C PRELIM.	S8 09/12/16	9 09/12/16	1 09.12.16	/ 09.12.16
09.12.21	130	FLAT PATTERN TOO LONG: 25.00 SHOULD BE 24.65. SCRAP QTY 1 MODIFY	09.12.21	Scrap + destroy No replace	S8 09/12/21	{ S 10/01/25	{ 1 09.12.21	{ S 10/01/25
		OTHER PARTS AS FOLLOWS: REDUCE FLAT PATTERN LENGTH BY 0.165" AT BOTH ENDS OF PLATE. THEN BRAKE/WD.	09.12.21					

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Page 4

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Required Date: 11/23/2009 Req'd Qty: 6.00

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo 8/10/13 (X) 0.00	0.00							

200 Packaging Packaging

210 QC Quality Control

POSITIVE RECALL
EFFECTIVE 10-10-14 AUTH U
RELEASED 10-10-14 DATE 10-10-14

is. 10-10-14 will be off of 10-10-14 to complete

10/10/14 H

10-9-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 30, 2009 1:11:13 PM

Page 1

Work Order ID: 53335



Parent Item: PB67-43001-31RevB1



Parent Item Name: PB67-43001-31 Upper Restraint Weldment

Start Date: 11/2/2009

Required Date: 11/23/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.090 		Purchased		No		180	sf	114.8403	2.7411	 5.65 3.66	10-10-17 10-10-17	10-10-17 10-10-17

6061-T6 .090 Sheet

Warehouse

Location

Main Warehouse

MAT	114.8403
108595	1.41
109184	16.3403
111382	96
19295	1.09

MS27039-1-09



Screw

Purchased

No

100 Each 765.0000 30.0000



10-10-13

Warehouse

Location

Main Warehouse

ST	765
107378	23
111650	500
18057	209
8912	33

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

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Required Date: 11/23/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149F0316P WASHER		Purchased	No			180	Each	96.0000	30.0000		<i>H 10.10.13</i>	

Warehouse

Location

Main Warehouse

ST	96
111117	9
111124	5
112940	82

PB67-43001-33RevB1

Manufactured No



Upper Pad Assembly

Warehouse

Location

Main Warehouse

ST	6
40294	1
41505	5

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53335
Description: Upper Restraint Weldment	Part Number:	B67-43001-31
Inspection Dwg: B67-43001 Pg41 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	<u>9-12-09</u> <u>SD-117</u>	Date:	<u>02/12/09</u>	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	08.09.05	New Issue		KJ/DD	<u>DS</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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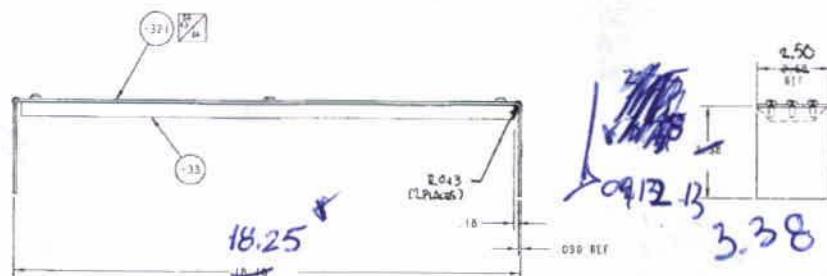
NOTE: Date & initial all entries

RELEASED
01-01-20

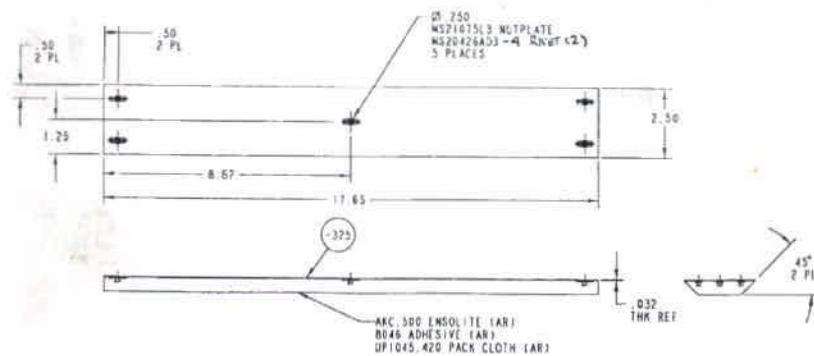
#53335



① 153 THRU
MACHINING WITH
EXISTING NUTPLATE
LOC'S OF -33
MS27039-1-09 SCREW
NAS114910316P WASHE
5 PLATES

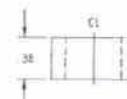


① -31 UPPER RESTRAINT WELDMENT

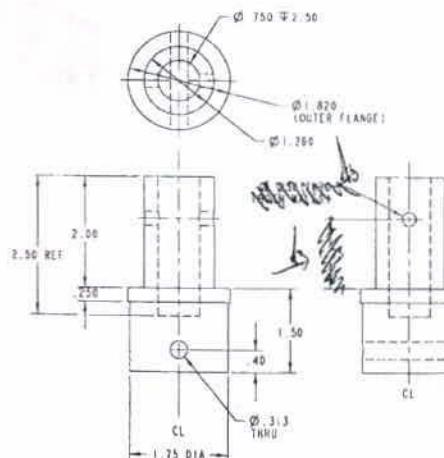


① -33 UPPER PAD ASSY

SCALE 0 500
NATL FOR 325: 032 THK 2024 T3 AL.
QQ A-250/4



(4) 299 BUSHING  



① -305 BEARING

JLM SCALE 1:000
MAT 2024-T3 AD
QQ-A-200/3

PREMIER AVIATION, INC.
2822 Aviation Parkway, Grand Prairie, Texas 75052

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

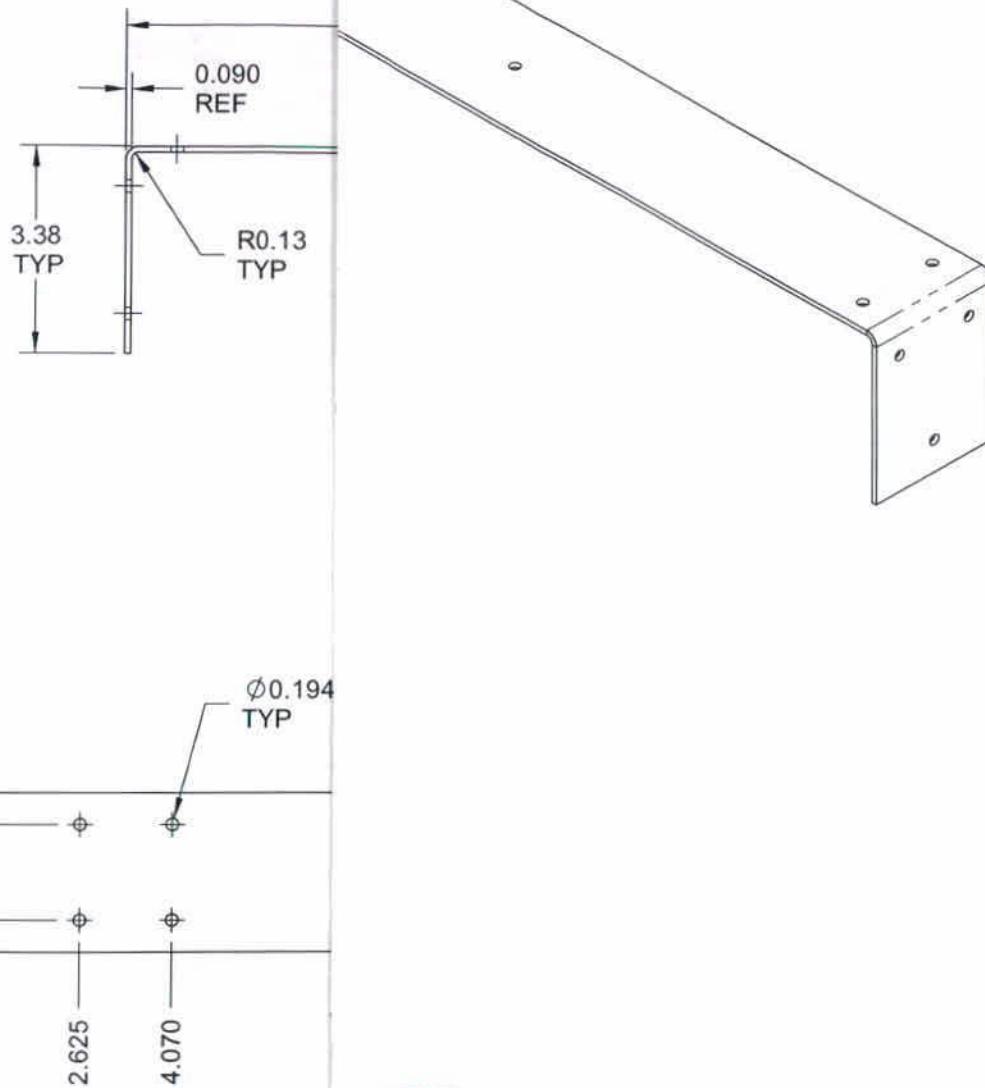
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D

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**PRELIMINARY
ISSUE** [09.12.2]

PREMIER AVIATION DRAWING IAW DART QSI 043. FOR PREVIOUS REVISIONS, REFER TO ND 43 OF PREMIER AVIATION DRAWING 01. REASON: SEE PAR#09-011.

MB 09.03.12

DESCRIPTION	BY	DATE
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO. B67-43001-321	REV. C	SHEET 1 OF 1
TITLE UPPER RESTRAINT PLATE	SCALE N/A	NTS
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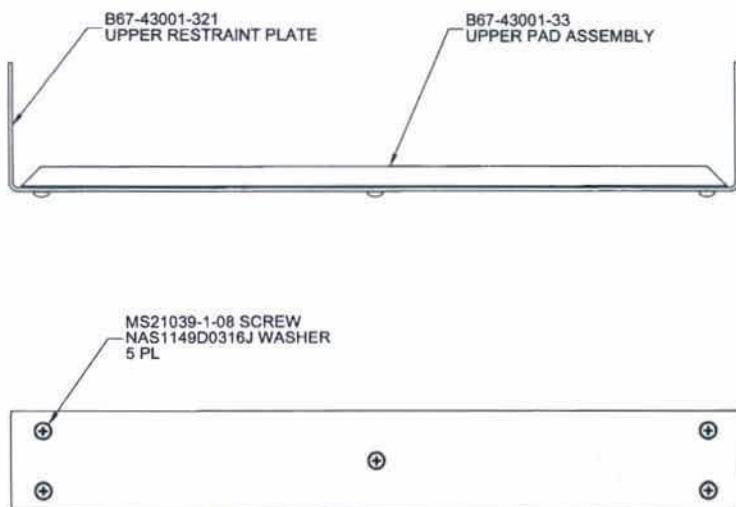
3

2

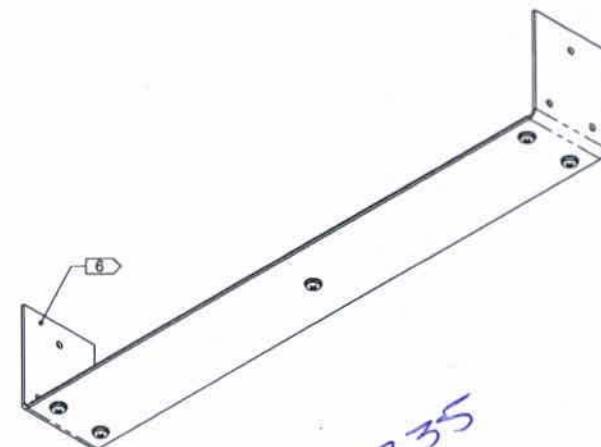
1

D

D



B67-43001-31 UPPER RESTRAINT ASSEMBLY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-31" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.76 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 041. FOR PREVIOUS REVISIONS, REFER TO SHEET 41 OF PREMIER AVIATION DRAWING NO. B67-43001, REASON: SEE PAR#09-011.			MB	09.06.19
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.	N/A				
DATE	09.06.19				

DRAWING NO. **B67-43001-31** REV. C
SHEET 1 OF 1
TITLE **UPPER RESTRAINT ASSEMBLY** SCALE NTS

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